

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024147**Date Inspected:** 31-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Liu Huajie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

Trial Assembly:-

Shielded Metal Arc (SMAW) welding of Weld Joint AH3150A-016,014(13AE, Side panel to Drip plate Weld, BK Side,PP118~120), and Welder is identified as 037743,066416; ZPMC Quality Control (QC) is identified as Mr. Zhang Yang Gang , The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3011-010(13CE Deck panel to Edge Panel Weld, BK Side), and Welder is identified as 068097,070007; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3019AH-003(13CE Edge Panel I Rib Weld, CB Side), and Welding Repair Report(WR)B-WR21036,Welder is identified as 066258; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G, (1F)-FCM-Repair-1.

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Flux Cored Arc (FCAW) welding of Weld Joint SA3058-003-003(13BE, Side panel I Rib Splice Weld), and Welder is identified as 055491; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Flux Cored Arc (FCAW) welding of Weld Joint SEG3011L-246,247(13CE Weld,PP122.5,BK Side), and Welder is identified as 051356; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-B-T-2233-ESAB/WPS-B-T-2232-ESAB.

Flux Cored Arc (FCAW) welding of Weld Joint SA3128-001-002(13CE+14AE, Side panel I Rib Splice Weld), and Welder is identified as 050242; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang, The welding variables appeared to comply with the Applicable WPS-B-T-2232-ESAB.

Flux Cored Arc (FCAW) welding of Weld Joint SA3039-001-009/010(13CE+14AE, Bottom panel I Rib Splice Weld), and Welder is identified as 050977; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang, The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
